

Date: Wednesday, 5/23/2007 3:24:31 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE SPACER
Job Number	32469	Part Number	D2935
Estimate Number	11063	Drawing Number	D2935 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	5/23/2007	S.O. No.	N/A
Prsh Rev.	NC	Type	SMALL /MED FAB
First Issue	N/A	Material	N/A
Previous Run	31793	Due Date	5/29/2007
Written By		Qty:	40
Checked & Approved By		Um:	Each
Comment	Est A 006.06 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		(40)
		Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s) Material: M6061-T6 0.080" Thick Batch <u>m104392</u>
		ml 07 06 10 (40)
2.0	WATER JET	FLOW WATER JET
		(40)
		Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>
		ml 07 06 10 (40)
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		(40)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		(40)
		Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		(40)
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1
		(40) 07-06-28 X40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/16/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 32469

Part Number: D2935

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



807/06/29 40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

807/06/29 40

8.0 QC21

FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

R1 07/06/29

Job Completion



U 07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32469
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

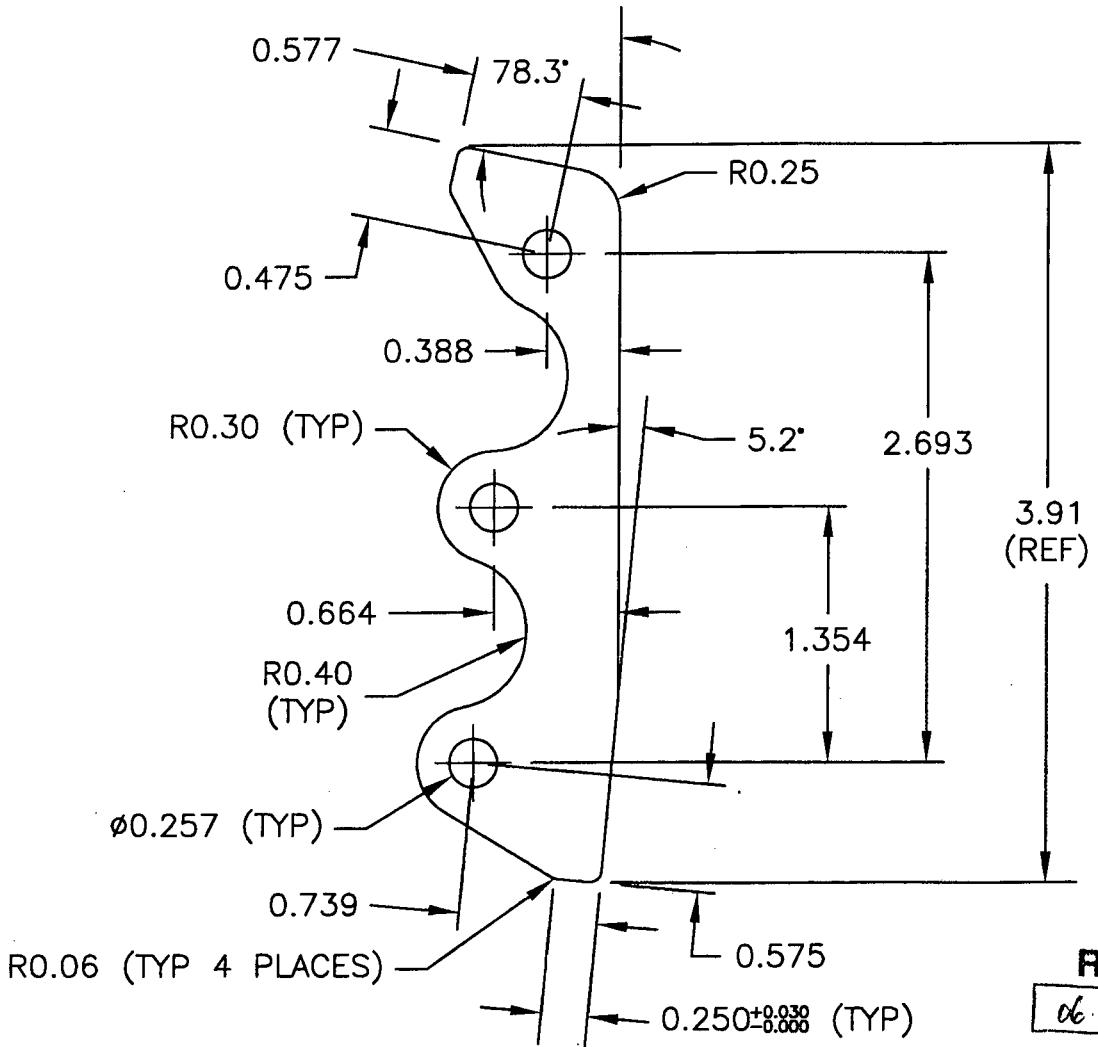
X First Article Prototype

Measured by:	<u>M. M.</u>	Audited by:	<u>S.</u>	Prototype Approval:	N/A
Date:	07/06/10	Date:	07/06/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>FF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32469

Copyright © 1999 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.